

Work Order ID 83111

Friday, April 13, 2012 8:22:31 AM

83111

Page 1

Item ID: D350-607-143

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Lid Opener Installation

Start Date: 4/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date: 12-04-12 Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								
100		0.00							
100									
DC		0.00							
Document Control	Memo Photocopy bluefile & type labels per PPP D350-607-143 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

J. J. M. 12-5-14

12/5/14

S. J. M. 12/5/14

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Start Date: 4/12/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-143								
	Location: <u>32</u>								
	PPP rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/5/15
12/5/15
12-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-607-143

Required Date: 4/26/2012

Required Qty: 1.00

IPP RevB: as
IPP Rev:C as per ecn10-

ST075	47
82035	47

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 83111

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-11 Manufactured No

110 Each 13.0000

D3953-11
Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

13

71268

1

79338

12

Manufactured No

110 Each 23.0000

D3953-15
D3953-15
Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

23

71269

2

79337

21

Manufactured No

110 Each 22.0000

D3953-17
D3953-17
Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

22

81206

22

Manufactured No

110 Each 13.0000

D3969-1
D3969-1
Spring (Basket Lid)

**

Location

Loc Qty

Loc Code

ST272

13

73523

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C11A Purchased No

110 Each

56.0000

**

AN3C11A
BOLT

Location

Loc Qty

Loc Code

ST351

56

118838

6

119798

50

Purchased No

110 Each

45.0000

**

AN3C15A
AN3C15A
Bolt

Location

Loc Qty

Loc Code

ST352

45

119973

45

Purchased No

110 Each

87.0000

**

AN310-4
AN310-4
NUT

Location

Loc Qty

Loc Code

ST344

87

120124

1

120518

25

121011

11

121162

25

121349

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,396.000

4 4

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

184

120693

184

ST301

1140

118077

2

118614

96

118686

30

119758

20

121255

992

MS24665-2-12

Purchased

No

110

Each

146.0000

2 2

MS24665-2-12

COTTER PIN

**

Location

Loc Qty

Loc Code

ST309

146

118078

146

NAS1149C0332R

Purchased

No

110

Each

2,777.000

4 4

NAS1149C0332R

Washer

**

Location

Loc Qty

Loc Code

ST297

257

119736

196

120648

61

ST298

2520

121255

2520

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-607-143

D350-607-143

Parent Item Name: Automatic Lid Opener Installation

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

4,996.000

2

2

NAS1149C0432R

**

12/15/12

Location

Loc Qty

Loc Code

ST297

1996

117291

996

119124

1000

ST298

3000

121255

3000

2 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	/ 1	1	D3953-3	GAS SPRING STUD (LID)
2	/ 1	1	D3953-5	GAS SPRING STUD (BASE)
2	/ 1	1	D3953-7	GAS SPRING SPACER
4	/ 2	2	D3953-9	GAS SPRING WASHER
2	/ 1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	/ 1		D3953-15	GAS SPRING BRACKET
	/ 1		D3953-17	GAS SPRING SPACER
2	/ 1	1	D3969-1	GAS SPRING
4	/ 2	2	AN3C11A	BOLT
	/ 2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	/ 2	2	AN310-4	CASTELLATED NUT
8	/ 4	4	MS21043-3	NUT
4	/ 2	2	MS24665-212	COTTER PIN
8	/ 4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	/ 2	2	NAS1149C0432R	WASHER (OR AN960C416L)